

Work Order ID 52452

September 25, 2009 7:25:20 AM



TODAY

Page 1

Item ID: D412-698-011

Accept



Setup Start



Revision ID: E

Stop



Item Name: Cabin Door Roller, LH

Start Date: 09/25/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-09-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL B-6

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

8/2/25

HJ for BG 09/09/25

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/9/25 TDS

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

27 8/2/25



d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-698-011

Accept

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Start Date: 09/25/2009 Start Qty: 1.00

Required Date: 09/25/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Rev B

2/9/25 R 9

Packaging

Identify and pack for shipping as per PPP D412-698-011
Location: 62

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

09/09/25 MF
09-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 52452

Parent Item: D412-698-011RevE

Parent Item Name: Cabin Door Roller, LH

Start Date: 09/25/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-141RevE		Manufactured	No			100	Each	11.0000	3.0000			



Bracket Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

11

46004

11

110

Each

5.0000

1.0000



D3121-143RevE

Manufactured

No



Bracket Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

46036

5

110

Each

10.0000

1.0000



D3183-043RevC1

Manufactured

No



Bracket Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

10

46030

10

46004 SP

* 45085 SP

9/19/25 @ SP

46030 SP
46030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52452

Parent Item: D412-698-011RevE

Parent Item Name: Cabin Door Roller, LH

Start Date: 09/25/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3137-043RevF		Manufactured	No			110	Each	39.0000	1.0000			



Bracket Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

39

42192

39

110

Each

45.0000

9.0000

42192 SP

D3199-1RevB

Manufactured

No



Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

45

46252

3

47848

42

110

Each

37.0000

1.0000

3 46252 47848 68

D3202-1RevD

Manufactured

No



Cover

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37

46005

1

46253

14

50134

22

46005 SP

9/19/25 RSD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

REFERENCE ONLY

52452